

Date: Thursday, 6/21/2007 2:29:34 PM  
 User: Kim Johnston

## Process Sheet

SPLIT-1

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BRACKET
Job Number	: 33066		
Estimate Number	: 11162		
P.O. Number	: N/A	Part Number	: D32641
This Issue	: 6/21/2007 S.O. No. : N/A	Drawing Number	: D3264 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A	Drawing Revision	: A
Previous Run	: 32201	Material	: N/A
		Due Date	: 7/12/2007
Written By	: <u>[Signature]</u>	Qty:	8 Um: Each
Checked & Approved By	: <u>[Signature] 07.06.22</u>		
Comment	: Est A 04.09.02 New issue KJ/JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
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1.0	M6061T6B1250X04500	6061-T6 Bar 1.25" X 4.5"
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Comment: Qty.: 0.5097 f(s)/Unit Total: 3.0580 f(s)  
 Material: 6061-T6/T651 (QQ-A-200/8 or 225/8) 0.500" thick  
 (M6061T6B1.250x04.500)  
 Identify for D3264-1  
 Batch: 117655

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW  
 Cut blanks: 4.500" x 1.250" x 5.700" long Bar

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1  
 Machine as per Folio FA447 and Dwg D3264  
 Identify as D3264-1  
 Deburr

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: PD Date: 07/08/30  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 6/21/2007 2:29:34 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 33066

Part Number: D32641

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

Handwritten: 07-08-24 (1)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Gloss White (Ref: 4.3.5.1) as per QSI 005 4.3

Handwritten: M105068, 07/08/29, (1X)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Handwritten: 7/8/29 SP, (1X)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N using a permanent fine point marker, then Stock

Location: \_\_\_\_\_

Handwritten: 7/8/29 SP, (1X)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Handwritten: 7/21/07, (1)

Job Completion



Handwritten: 7-08-30



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

DART AEROSPACE LTD		Work Order: 33066
Description: Bracket		Part Number: D3264-1
Inspection Dwg: D3264	Rev: A	Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.687	+/-0.010	0.689	—			
0.063	+/-0.010	0.064	—			
0.125	+/-0.010	0.130	—			
0.875	+/-0.010	0.880	—			
0.062	+/-0.010	0.060	—			
R0.03	+/-0.030	R0.030	—			
R0.13	+/-0.030	R0.130	—			
1.00	+/-0.030	1.007	—			
0.125	+/-0.010	0.127	—			
0.600	+/-0.010	0.598	—			
4.000	+/-0.005	3.999	—			
0.750	+/-0.010	0.752	—			
Ø0.194	+0.005/-0.000	Ø0.194	—			
5.50	+/-0.030	5.507	—			
0.125	+/-0.010	0.128	—			
0.063	+/-0.010	0.067	—			
R0.25	+/-0.030	R0.25	—			
4.27	+/-0.030	4.277	—			
R0.30	+/-0.030	R0.30	—			

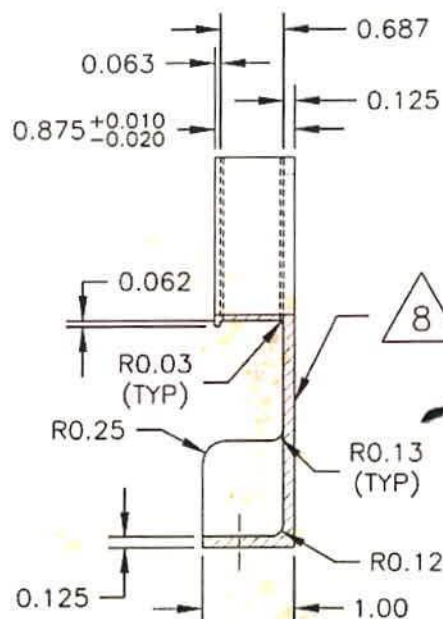
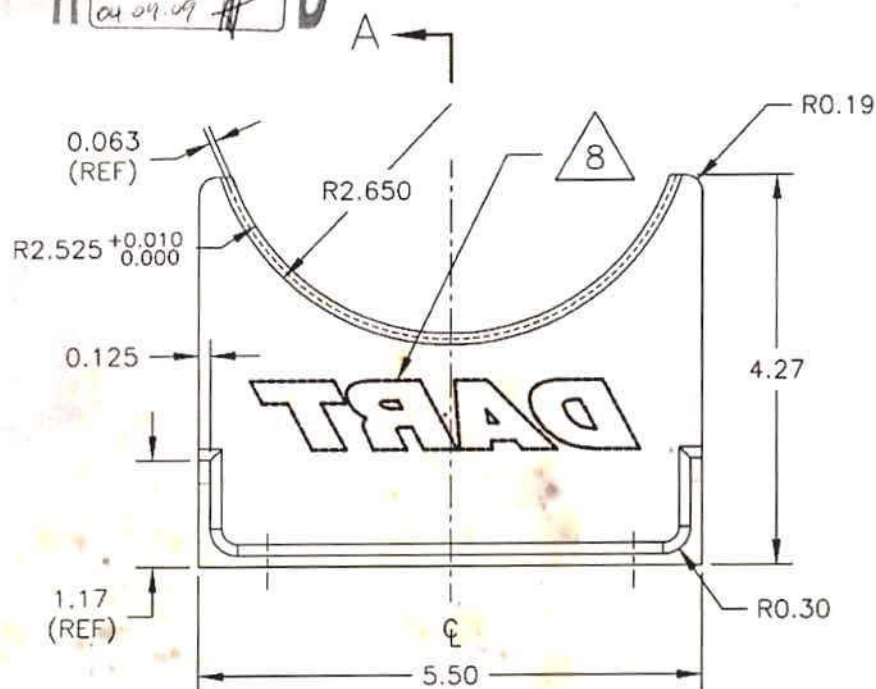
Measured by: <i>JMK</i>	Audited by: <i>J.L</i>	Prototype Approval:	N/A
Date: 07/08/24	Date: 07/08/24	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.09.03	New Issue	KJ/JLM	
B	05.04.26	Ø0.194 was Ø0.208; dimensions removed	KJ/JLM <i>JA</i>	<i>Spd</i>

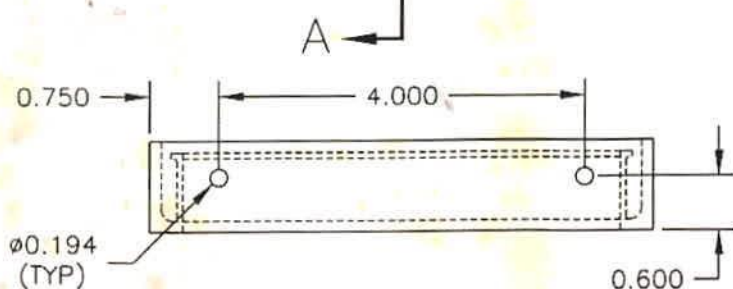


DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3264	REV. A SHEET 1 OF 1
DATE 04.04.20		TITLE BRACKET	SCALE 1:2
A	04.04.20	NEW ISSUE	

RELEASED  
04.04.09 #



SECTION A-A



D3264-1 BRACKET

D3264-1:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8) (REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) PART IS SYMMETRIC ABOUT CENTERLINE
- 7) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT MARKER
- 8) ENGRAVE DART LOGO AS SHOWN USING 0.75 HIGH x 0.010 DEEP (MAX) LETTERS WITH (MIN) TOOL RADIUS OF 0.25

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NO. 33066